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D2563

Job Sheet 199945



Part No: D2563

Job Qty: 6 pcs

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 10/28/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Welded Assy-1	6 pcs		10/28/19	0.00	8.82	Large Fab - 1		
						12/89	Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3	DAS	
							Large Fab - 4	24	SEP 11 2019
							Large Fab - 5	8-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		Jas
							Large Fab - 11 (Various)		
110	QC 9	6 pcs		10/28/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43	DAS	
							QC 9 - 50	43	
							QC 9 - 9	8-89	
120	QC 5	6 pcs		10/28/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3	DAS	
							QC 5 - 43	43	
							QC 5 - 49	8-89	



Container No: S212995



Part: D2563

Job No: 199945

Serial No/Batch: S212995

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/11/10

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					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
130 Handfinish - 1-1 Chemical-B4B	6 pcs	10/28/19	0.00	1.61	Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	6 pcs	10/28/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	

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						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	DAS
						QC 7 - 24	24
						QC 7 - 43	9-89
						QC 7 - 61	
						QC 7 - 81	
150 Large Fab - Welded Assy-2-B4B	6 pcs	10/28/19	0.00 8.82			Large Fab - 1 - B4B	
						Large Fab - 10 - B4B	
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	DAS
						Large Fab - 7 - B4B	24
						Large Fab - 8 - B4B	9-89
						Large Fab - 9 - B4B	
						Large Fab - 11 - B4B (Various)	
160 QC 10	6 pcs	10/28/19	0.00 0.00			QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	DAS
						QC 10 - 50	43
						QC 10 - 58	9-89
						QC 10 - 9	
170 QC 5	6 pcs	10/28/19	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	DAS
						QC 5 - 49	43
						QC 5 - 51	9-89
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
175 Handfinish - 2-1 Pressure-B4B	6 pcs	10/28/19	0.00 1.61			Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
180 Powdercoat - 1 White Gl(A)-B4B	6 pcs	10/28/19	0.00 1.00			Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
190 Handfinish - 3-1- WingWalk-B4B	6 pcs	10/28/19	0.00 1.61			Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	

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200 QC 3	6 pcs	10/28/19	0.00 0.00	Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	6 pcs	10/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

DAS
81
9-89

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ML

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	6 pcs	10/28/19	0.00 0.00	QC 21 - SA - 21	DAG	SEP 18 2019
				QC 21 - SA - 70	21	
				QC 21 - SA - 53	0.89	

Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: 138872) 1-Grind D2244 to 89.70" at 34 deg as per dwg D2563 2-Debur ends
 Descriptions: 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Weld per dwg A/R Aluminum rod Batch: 138872) 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap
 as per Dwg D2563 using DT 8343 3-Grind
 160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 175 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch up Alodine as per QSI005
 180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as
 per QSI 005 4.3 START TIME: _____
 190 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	6 pcs (1 ea)	100-Large Fab - Welded Assy-1	5081118
D2561	Lug	12 pcs (2 ea)	100-Large Fab - Welded Assy-1	5192591
D2564	Mounting Angle	12 pcs (2 ea)	100-Large Fab - Welded Assy-1	5165433
D2673-34	End Plate	6 pcs (1 ea)	100-Large Fab - Welded Assy-1 <u>5240765</u>	5192727
D2673-34	End Plate	6 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	5192727

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	6	95	0
	D2561	12	24	0
	D2564	12	23	0
	D2673-34	6	38	0
	D2673-34	6	38	0
150-Large Fab - Welded Assy-2- B4B	D2673-34	6	38	0

Part Specifications

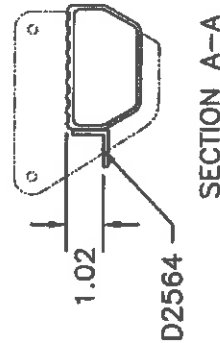
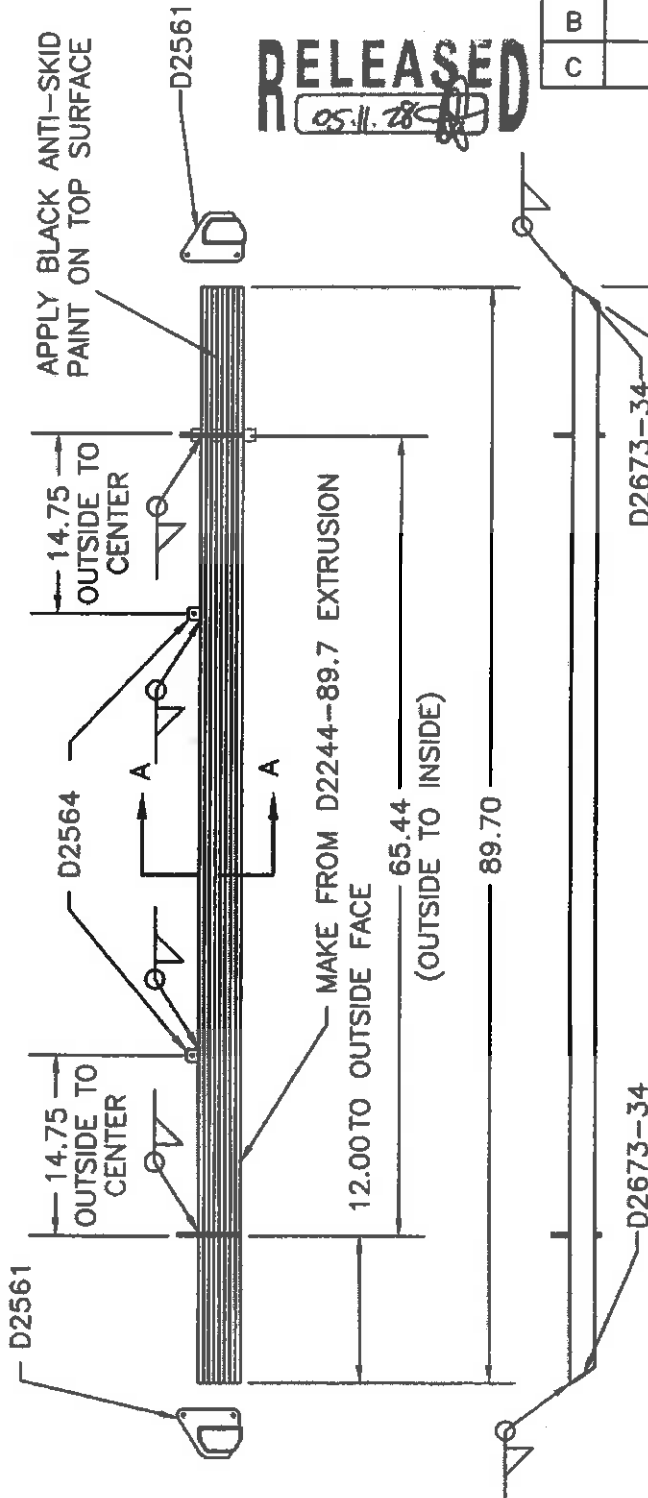
Specifications could not be found.

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011827

DART**RELEASED**
05.11.14

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2563	REV. C SHEET 1 OF 1
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY		SCALE 1:15
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

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WITHOUT NOTICE
WORK ORDER
NO. 199945

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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